

Date: Tuesday, 10/02/2009 3:10:01 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 45732		
Estimate Number	: 13582		
P.O. Number	:	Part Number	: D38201
This Issue	: 10/02/2009 S.O. No. :	Drawing Number	: D3820 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 42079	Material	:
Written By	:	Due Date	: 20/02/2009 Qty: 10 Um: Each
Checked & Approved By	: <u>JLD 09.02.10</u>		
Comment	: Est Rev:A New Issue 08-09-17 JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	6061T6S125	6061-T6 .125 Sheet
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Comment: Qty.: 0.0543 sf(s)/Unit Total: 0.5429 sf(s)
 6061-T6 .125 Sheet

HB 9-3-3

HB 9-2-22

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3820

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

HB 9-3-3
HB 9-2-22

09/03/10

(28) (28) (28) (28)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 9-3-3
HB 9-2-22

PTC

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

09/03/10 (28)

5.0	BRAKE NC	NC BRAKE
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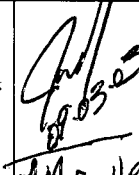

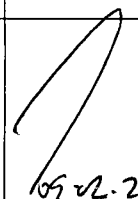
Comment: NC BRAKE

Bend as per Dwg D3820

09/04/01 (28)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3820-1 PAR #: N/A Fault Category: Production Coordinator NCR: (Yes) No DQA: 12 Date: 09/04/15
1130-780-011
Resolution: Documentation Revised Disposition: Scrap QA: N/C Closed Date: _____

NCR: 45732		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-02-23	2-0	All 15 parts are scrap. Upon piercing the 0.098" hole, the pressure oversized the top side of the hole from 0.100" → 0.120" OD; the hole was not round on the other side.	 05/04/12	Review and Test Data DXF WAS WRONG Scrap & destroy all 15 parts & replace.	 09-03-10 for HB	S 09/04/14	 05/04/12	 09-02-24
		R.C: Incorrect hole's on DXF.			09-03-10			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 45732

Part Number: D38201

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/04/08 counter
(x28)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ump/14

09/04/06

(x28)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

1:55

OVEN TEMPERATURE:

320°

FINISH TIME:

2:25

FL 09/04/08

(28)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

B.L 09-04-8

(28)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 137

9/4/9

(28)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/13

Job Completion



mk

09-04-09

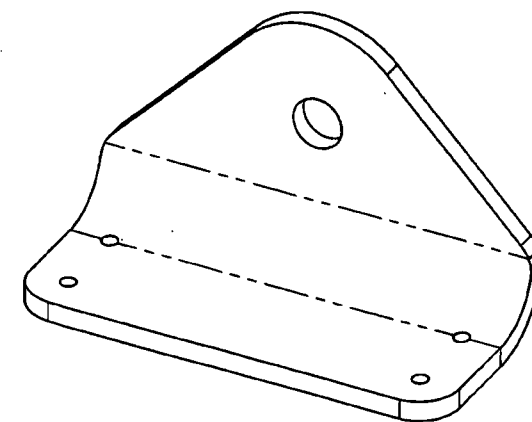
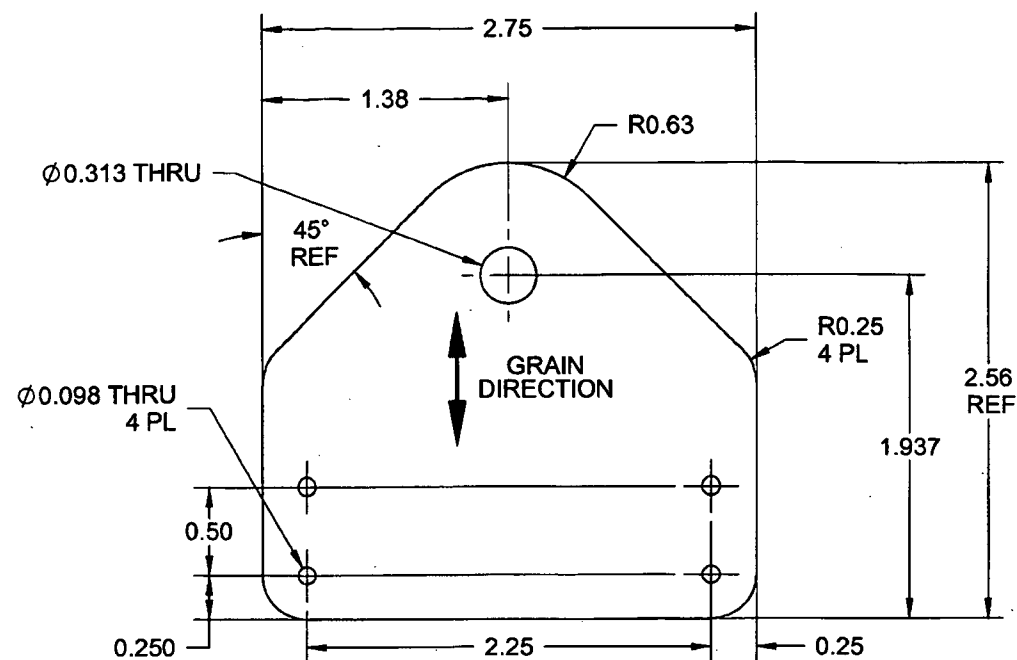
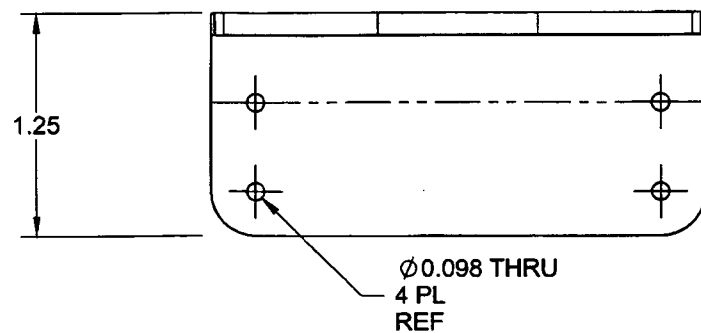
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

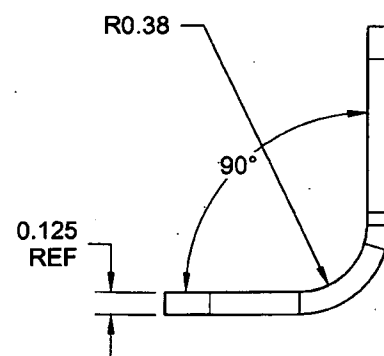
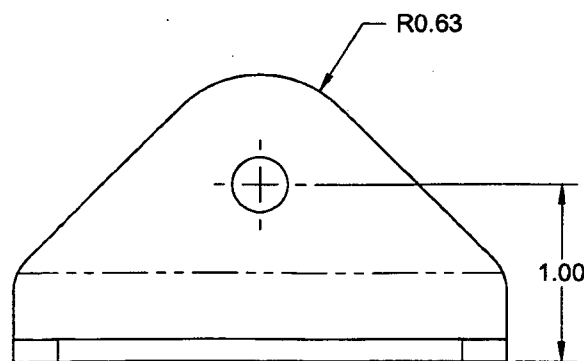
NOTE: Date & initial all entries



OK 898
- 1565
8435

1565
25313
2
11
10
13
12
10

D3820-1F BRACKET FLAT PATTERN



D3820-1 BRACKET
(MADE FROM D3820-1F)

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) 0.125 ALUMINUM SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3820-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.07 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
45732

RELEASED
09/01/13

A	NEW ISSUE	08.10.02
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	08.10.02	

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3820	REV. A SHEET 1 OF 1
TITLE BRACKET	SCALE NTS
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